

5/15

DART AEROSPACE LTD	Work Order:	22366
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Dwg: D3065 Rev. A1 42	Qty:	40
RF 03.02.17 RF 03.02.28		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <i>Dwg. not required RF 02.11.04</i> (Minimum lots of 30)	HA	05.02.08	40
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M16241</u> Identify as D3065-1 <i>4.320" RF 02.11.29 4.320"</i>	EP	05/02/23	50 ¹³
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.320") <i>4.250" RF 02.11.29 4.320"</i> Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M16241</u> Identify as D3065-3	EP	05/03/23	50 ⁷
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M16241</u> Identify as D3065-7	EP	05/03/23	50 ¹⁰
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch <u>M16241</u> Identify as D3065-5 (Note: make 2 legs per assembly) <i>M17124 M15673</i>	EP	05/04/28	100
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch <u>M15673</u> Identify as D3066-1 (Note: make 2 spacers per assembly)	SD	05/03/24	100
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	EP	05/03/24	50
8	MV	Deburr to take measurement	EP	05/03/24	50 ^{Pto}
9	QC2	Inspect parts as they come off the CNC machine	EP	05/03/24	50
10	QC8	Second check	ML	05/03/24	56
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	EP	05/03/24	50
12	MV	Deburr to take measurement	EP	05/03/24	50
13	QC2	Inspect parts as they come off the CNC machine	EP	05/03/24	50
14	QC8	Second check	ML	05/03/24	56
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	EP	05/03/28	50
16	MV	Deburr to take measurement	EP	05/03/28	50
17	QC2	Inspect parts as they come off the CNC machine	EP	05/03/28	50
18	QC8	Second check	ML	05/03/29	56
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.			

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RELEASED

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR: 22366		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/03/29	#19	one stack scrap (D3065-5) Parts moved	<i>VB</i> prosser	scrap & replace	<i>EP</i> 05/03/29	<i>VB</i> 05.03.29	<i>VB</i> prosser	<i>VB</i> 050329
05/03/28	#7	one stack scrap (D3065-1) tool broke moved stack	<i>VB</i> prosser	scrap & replace	<i>EP</i> 05/03/29	<i>VB</i> 05.03.29	<i>VB</i> prosser	<i>VB</i> 050329
05/04/22	#28	piece D3065-7 1 scrap bend over tolerance	<i>VB</i> prosser	scrap	<i>VB</i> 05/04/22	<i>VB</i> 0504.26	<i>VB</i> prosser	<i>VB</i> 050426

Part No: D3065-041 PAR #: _____ Fault Category: Prod / Mfg NCR: Yes No DQA: OP Date: 05/05/23

NOTE: Date & initial all entries

QA: N/C Closed: VB Date: 05.05.05